

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027164**Date Inspected:** 09-Feb-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** L&M Industrial Fabricators**Location:** Tangent, OR**CWI Name:** Thomas Dreyer**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** CCO 196 and 203**Summary of Items Observed:**

On this date, Quality Assurance Inspector (QAI) Kenneth Riley arrived at L & M Industrial Fabricators between the times noted above to randomly observe Quality Control (QC) personnel monitor the welding operations performed by L & M personnel on the fabrication of chimney parapet walls to the Tower Heads and Elevator brackets installed. The observations for the extra work being performed are under contract change orders CCO196 and CCO203 as stated below.

A) CCO196

B) CCO203

A). CCO196

The QAI observed that PSI QC inspector Leo Jim was onsite to perform Magnetic Particle (MT) and Ultrasonic Testing (UT) on tower head to parapet weld A6B. The location is where a longitudinal indication was previously discovered during the MT testing. This QAI observed the testing and was informed that both methods for this repair was acceptable. This QAI then proceeded to perform a QA review also using the MT and UT method and found no rejectable indications at the time of the review. For further information please see TL-6027 and TL-6028 dated for today. At the time of the observations no issues were noted by the QAI.

B). CCO203

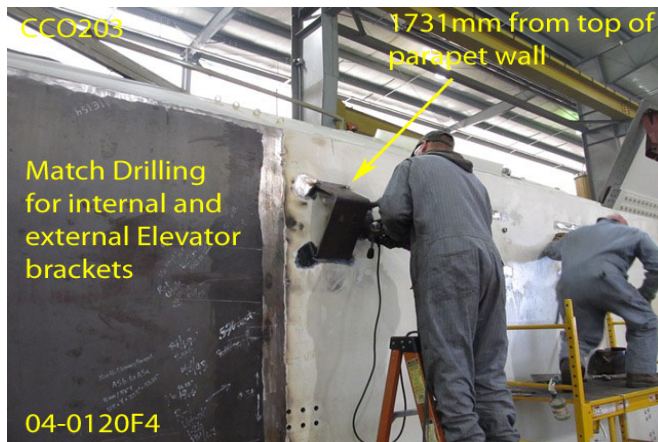
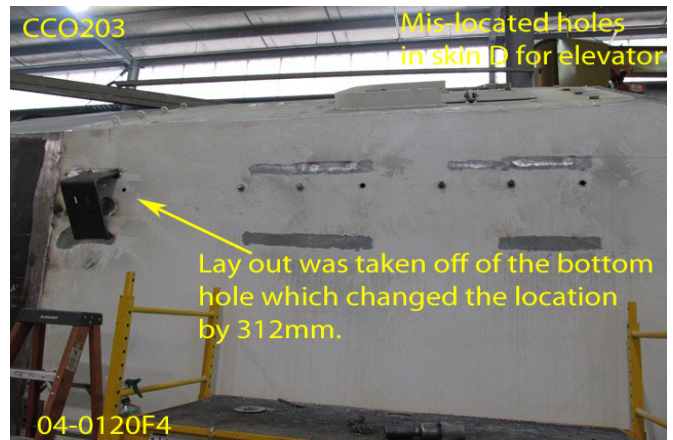
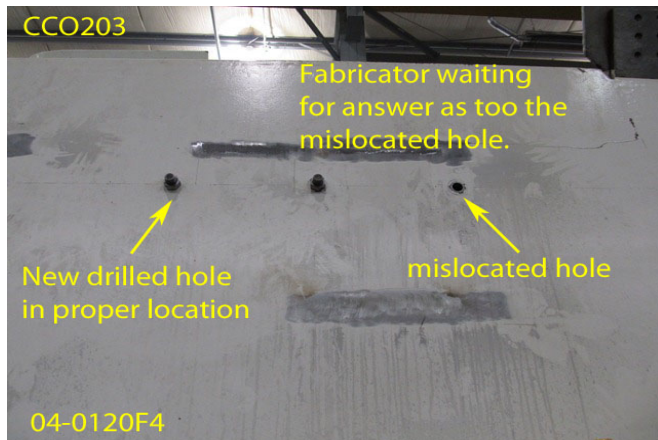
This QA Inspector randomly observed L & M welding personnel Otis Smith (Welder ID #19), Bradford Schroyer

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(Welder ID #16) and Jake Schuld were fitting and drilling the internal and external elevator brackets. The fabricator was using a Mag-Drill with a 23mm size bit for the holes. During the drilling it was discovered that the layout was wrong for the brackets and that the dimension had been taken from the bottom hole located at 1731mm instead of the top at 1419mm. This has caused the layout to be off by 312mm. there 4 additional holes at each location for the external and internal brackets (total of 8 holes). These are located on skin D (4) and the internal stiffener (4). The fabricator QC Inspector Tom Dreyer has contacted the contractor ABF who is sending a Request For Information (RFI) to the Caltrans Engineer for resolution.

Unless noted otherwise, all work observed on this date appeared to be in general compliance with the contract documents at the time of observations.



Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI and ABF QC personnel.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
